

Split ⑥

DART AEROSPACE LTD	Work Order:	22291 - 2
Description: Slider Body	Part Number:	D3372-7
Dwg: D3372 Rev. A <i>page 7</i>	Qty:	50.25
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty								
1	DC	Issue Traveler	U	05.02.17	25								
2	MV	Cut blank: 1.500" x 1.250" x 4.435" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.250) Identify for D3372-7 Batch: <u>M17037</u>	J.L	05/07/12	25								
3	MV	Machine D3372-7 as per Folio FA495 and Dwg D3372 Identify as D3372-7	J.L	05.07.12	25								
4	QC2	Inspect parts as they come off the CNC machine	J.L	05.07.12	25								
5	QC8	Second check	Be	05.07.12	25								
6	MV	Deburr	J.L	05.07.12	25								
7	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.14	25								
8	QC3	Inspect Chemical Conversion Coat	M	05.07.14	25								
9	MV	Fabricate D3372-9 using AN6-36A bolt. Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>AN6-36A</td><td>Bolt</td><td><u>M17405</u></td></tr></table>	Qty	Part Number	Description	Batch	1	AN6-36A	Bolt	<u>M17405</u>	FF	05.11.21	25
Qty	Part Number	Description	Batch										
1	AN6-36A	Bolt	<u>M17405</u>										
10	QC5	Inspect work to Step 9	MS	06/01/18	25								
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask all holes and pins	ML	06.02.01	25								
12	QC3	Inspect Powder Coat	SB	06/02/01	21								
13	ST	Identify and Stock <u>LOC: 63</u>	CL	06/02/06	21								
14	AC	Cost / part	Syr	06.02.07	21								
15	DC	Close W/O Inspect Level 21	D	06/02/07	21								

Rev	Date	Change	Revised By	Approved
A	05.01.18	New issue	KJ/JLM	

RELEASED
05.01.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.12	3	-1 part chamfer dimension is .730 instead of .630 "error in program" -is part acceptable?	<i>[Signature]</i>	IT IS ACCEPTABLE FOR (1) PART OF THIS W/O. UPDATE CNC PROGRAM TO CORRECT THE DIMENSION AS PER DWG.	<i>[Signature]</i> 05.07.12	<i>[Signature]</i> 05.07.12	<i>[Signature]</i>	<i>[Signature]</i> 05.07.12
05.11.21	9	1 ANS-36A Bolt short	<i>[Signature]</i> 05.11.21	Destroy.	<i>[Signature]</i> 05.11.21 FB	<i>[Signature]</i> 05.11.21	<i>[Signature]</i>	<i>[Signature]</i> 05.11.21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: *06/02/17*

NOTE: Date & initial all entries

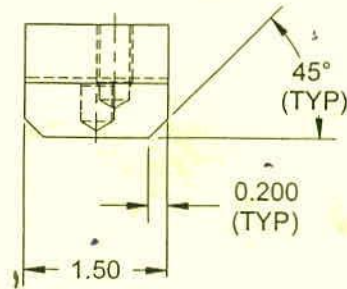
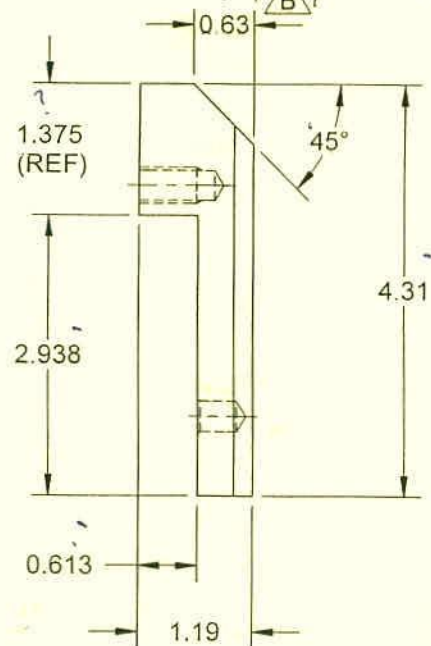
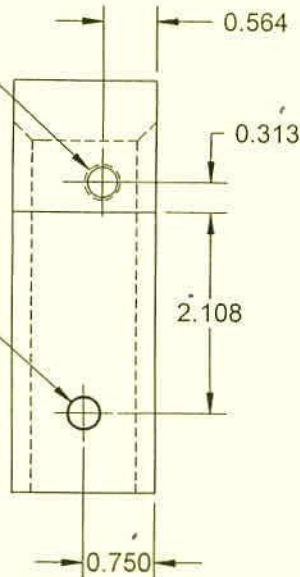
QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 7 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
[Signature]
05/04/23
B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22291

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No : 0022291
Project Name : D3372-7
Project For : WK507
Work Order Type : Main
Main WO Number :
House Part Number : D3372-7
Description : Slider Body
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 22291
Description: slider body		Part Number: 3372-7
Inspection Dwg: 3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.750	$\pm .010$.748	✓		vern	
2.108	$\pm .010$	2.111	✓		h-gauge	
.313	$\pm .010$.312	✓		h-gauge	
.564	$\pm .010$.563	✓		vern	
Ø.332 x .881 deep	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.333	✓		vern	
Ø.323 x .500 deep	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.325	✓		vern	
.200	$\pm .010$.205	✓		vern	
1.500	$\pm .030$	1.499	✓		vern	
.630	$\pm .030$.625	✓		vern	
45°	✓	✓				
2.938	$\pm .010$	2.937	✓		vern	
1.375						
4.31	$\pm .030$	4.318	✓		vern	
.613	$\pm .010$.614	✓		vern	
1.19	$\pm .030$	1.189	✓		vern	

Measured by: J-L	Audited by: [Signature]	Prototype Approval:
Date: 05.07.12	Date: 05.07.12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

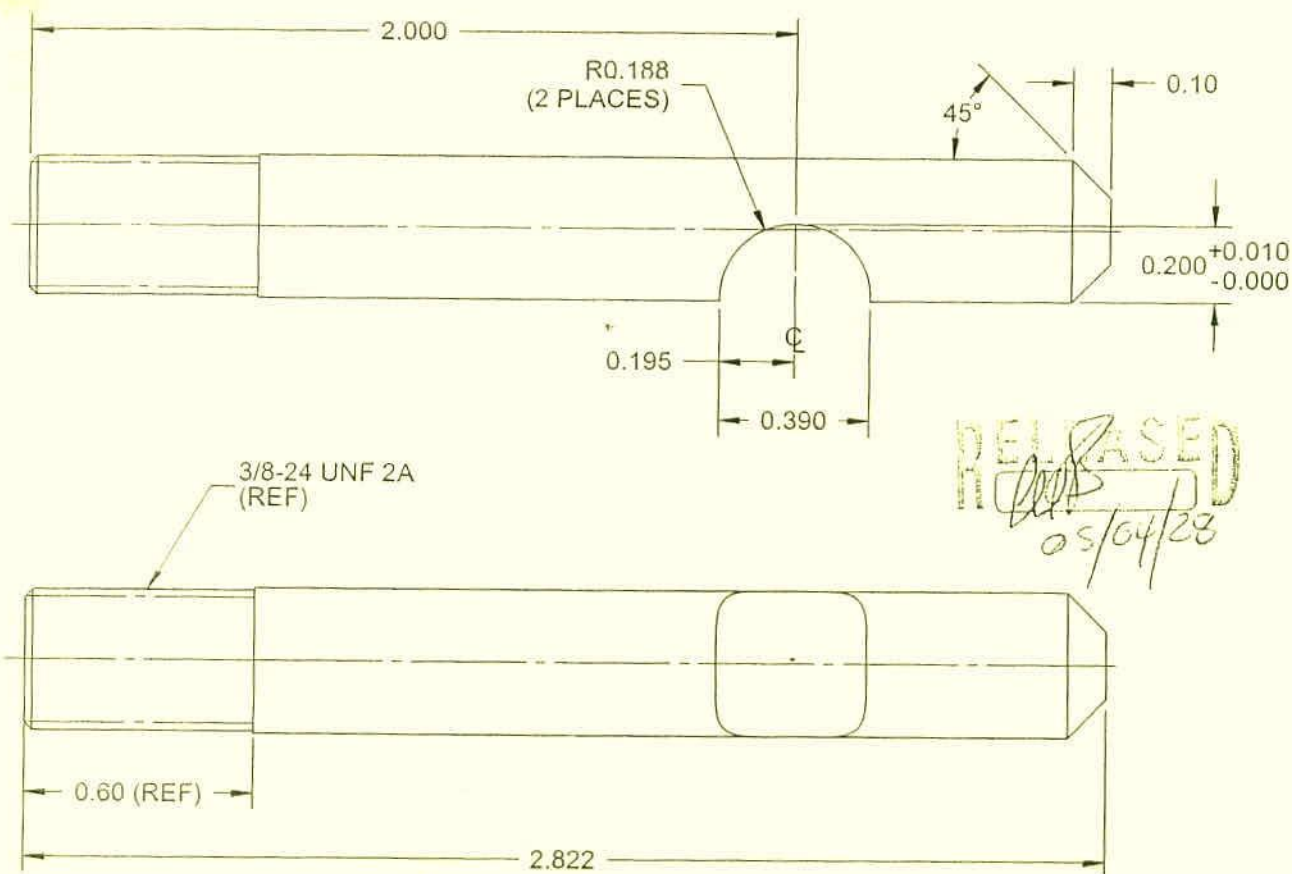
REFERENCE ONLY
CONTROLLED COPY



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7#	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

REFERENCE ONLY

SPECIFICATION CONTROL DRAWING



REFERENCE ONLY

D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

REPHENES-UNIT

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:12 am

Work Order No : 0022291
Project Name : D3372-7
Project For : WK507
Work Order Type : Main
Main WO Number :
House Part Number : D3372-7
Description : Slider Body
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	10.50	100.00		
Production Cost :	0.00	181.55	100.00	0.00	181.55
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	10.25	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	181.55	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	181.55			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-181.55)

MIS 01B
u
11-13

Date: Monday, 14/11/2005 8:44:23 AM
User: Alba Panzuto











Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SLIDER BODY
Job Number :	22291		
Estimate Number :	10448		
P.O. Number :		Part Number :	D33727
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3372 REV B
First Issue :	/ /	Project Number :	
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/11/2005
Written By :		Qty:	25
Checked & Approved By :		Um:	Each
Comment :	EsT A 05.01.18 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
2.0	BAND SAW	BAND SAW
		
Comment: Cut blank: 1.500" x 1.250" x 4.435" long Machine D3372-7 as per Folio FA495 and Dwg D3372 Identify as D3372-7 Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
7.0	AN636A	BOLT

Date: Monday, 14/11/2005 8:44:23 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDER BODY

Job Number: 22291

Part Number: D33727

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-9 using AN6-36A bolt.

Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



